Large Fab

92909

Page 1

November-12-12 3:24:07 PM Item ID: 647.7701 Accept *N900040100* Setup Start Revision ID: Item Name: Strut Assembly **Start Date:** 12/11/2012 Start Qty: 4.00 Cust Item ID: **Required Date:** 03/12/2012 Req'd Qty: 4.00 **Customer:** Reference: Run MLJ Date: 12-11-12 Tooling: **Approvals:** Process Plan: Date: Stop Date: **SPC (Y/N):** QC: Date: Sequence ID/ Operation Set Up/ **Tool ID** Tool # Plan Reject Accept Reject Insp. Work Center ID Description Code Qty Qty Number Stamp **Run Hours Draw Nbr Revision Nbr** 647.7700 N/C 110 Pick Kit 0.00 9 @ 13-3-6 *110* Packaging 0.00 Memo Packaging Weld per dwg A/R 4130 rod Batch: M//8/875 120 9 A 13-3-6 *120* Large Fab 0.00 Memo

2- ON STRUT THREAD REMOVE CADE PLATE ONLY WHERE NEEDED BEFORE WELDING

***IMPORTANT DIMENSION IS 11.60" ***

1- ASSEMBLE AND WELD AS PER DWG

										DQA:	Date:		
NCR:	Yes /	' No				WORK ORDER NON-C	ONFOR	MANCE / U	PDATE				
										QA Closed:	Date:		
Work Ord	or.					DISPOSITION			AGAINST DE	PARTMENT/PROCESS			
Part f	 No					Rework Scrap Use-as-is Work Order Update	Skid-tube Crosstub Machining Small Fa Thermoforming Finishin Large Fab Composit			1	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other	
Root					Descri	otion of work order update	Initial	А	action	Sign &			
Cause		Date	Step	Qty		or Non-conformance	Chief Eng	Des	scription	Date	Verification	QC Inspector	
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	\vdash	ending				Bend	Grain			Ovalized	<u> </u>	Pressure/Forced	
	L_C€	entre No	t Concen	itric to	o/s	BOM/Route	Hardwa	re		Over/Under	 	Temperature/Cure	
	⊢–-	acks			ļ	Broken/Damaged	⊢	on Incomplete		Part Incorre		Weld	
	Crushed/Crimped.					Burrs	—	ions Incomplete	e/Unclear	Part Lost/M	- <u>-</u>	Wrong Stock Pulled	
	∐ ^{Cւ}	ıffs				Contamination	Maintenance			Part Moved			
	He	eat Treat	t			Countersink Mislabeled				Positioned Wrong			
	l ln	cnaction	Strin in	Tuho		Cut Too Short	Microso	Power Loss	Surge	Other			

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

November-12-12 3:24:07 PM

Item ID: 647.7701 Accept *N900040100* Setup Start **Revision ID:** Strut Assembly Item Name: **Start Date:** 12/11/2012 Start Oty: 4.00 **Cust Item ID: Required Date:** 03/12/2012 Reg'd Qty: 4.00 **Customer:** Reference: Run Process Plan: Date: ____ Tooling: **Approvals:** Date: Date: ____ SPC (Y/N): OC: Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Accept Reject Work Center ID Description Qty Code Qty Number Stamp **Run Hours** 130 QC9- Inspect visual per QSI004- Fusion Welds 0.00 (1) 13-03-06 (19) *130* OC 0.00 Memo Quality Control 140 QC5- Inspect part completeness to step on W/O 0.00 QC 0.00 Memo Quality Control 150 0.00 4 Ø Ø Al *150* SprayPaint 0.00 Memo Spray Painting PRIOR TO PRIME MASK THREAD AND PRIME AS PER DWG PRIMER BATCH: 125452

				DQA:
NCR:	Yes /	No	WORK ORDER NON-CONFORMANCE / UPDATE	

NCR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE																
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						1	Use-as-is]	Thermoforming Finishing			ing	Rec/Stor	e/Packaging	Other	
NCR N	lo.					Work O	der Update		Large Fab Composite			site		Supplier		
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ŀ		Crushed/C	Crimped.		-	Burrs			i	ions Incomplete/	Unclear		Part Lost/Mi	ssing	Wrong Stock Pulled	
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}		Heat Treat		Tuba	-	Countersink		-	Mislabe			-	Positioned W		Joshor	
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. }	_	Rippies in Torque W		vtrucion	,	H		Offset								
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Outside Dimensions

Date:

Wave/Twist in Tube

November-12-12 3:24:07.PM Item ID: 647,7701 Accept *N900040100* Setup Start **Revision ID:** Item Name: Strut Assembly Start Date: 12/11/2012 Start Oty: 4.00 **Cust Item ID: Required Date:** 03/12/2012 **Rea'd Otv:** 4.00 **Customer:** Reference: Run Process Plan: Date: Approvals: Tooling: Date: QC: _____ Date: ____ **SPC (Y/N):** Date: Operation Sequence ID/ Set Up/ Tool ID Tool # Plan Accept Reject Reject Insp. Work Center ID **Description Run Hours** Code **Qty** Oty Number Stamp 160 0.00 **S** QC14- Inspect Spray Paint *160* Memo Quality Control Identify as per dwg & Stock Location: 57/39 E 0.00 170 *170* Packaging 0.00 Memo ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING THE P# AND Packaging REV*** 180 QC21- Final Inspection - Work Order Release 0.00 *180* WK 6-10 0.00 Memo Quality Control

			DQA:	Date:	
NCR:	Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE			

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Work Orde	r:				DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Part N					Rework Scrap Use-as-is	The	Skid-tube Machining rmoforming	Crosstube Small Fab Finishing	—	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other			
NCR N	0				Work Order Update	<u> </u>	Large Fab	Composite		Supplier				
Root				Descri	ption of work order update	Initial	, ,	Action	Sign &	,				
Cause	Date	Step	Qty		or Non-conformance	Chief Er	ng De:	scription	Date	Verification	QC Inspector			
Doc/Data														
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Setup					•	37					·			
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Ĺ	Bending				Bend	Grain	1		Ovalized		Pressure/Forced			
	Centre No	ot Concer	ntric to (o/s	BOM/Route	Hard	ware	. [_	Over/Under	tolerance	Temperature/Cure			
	Cracks				Broken/Damaged	Inspe	ction Incomplete		Part Incorre	ct	Weld			
· [Crushed/0	Crimped.			Burrs	Instru	ictions Incomplete	e/Unclear	Part Lost/M	issing	Wrong Stock Pulled			
	Cuffs				Contamination	Mair	itenance		Part Moved		_			
	Heat Trea	it			Countersink	Misla	beled		Positioned V	Vrong				
	Inspection	n Strip in	Tube		Cut Too Short	Misre	ead		Power Loss/	Surge	Other			
	Ripples in	Bend			Drill Holes	Offse	t	•						
	Torque W	aves in E	xtrusior	· [Drawing	Out o	f Calibration		•					
	Turning So	equence			Finish	Out o	f Sequence							
Γ	Wave/Tw	ist in Tub)e		Folio	Outsi	de Dimensions							

Picklist Print

November-12-12 3:24:12 PM

Work Order ID: 92909

92909

Parent Item:

647.7701

647 7701

Parent Item Name: Strut Assembly

Start Date: 12/11/2012

Required Date: 03/12/2012

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP REV:A 12.11.01 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
647.7710		Manufactured	No			110	Each	0.0000	1	4			
*647 7710 Strut Tube	*			92911	× 4				**		_13:-3	6	
647.7712		Manufactured	No			110	Each	0.0000	1	4			
*647 7712 Strut Tube	*			7320	3 x 4				**	A	13-3	-6	
647.7713		Manufactured	No			110	Each	0.0000	1	4			
*647 7713 Strut Thread	*			932	45 X4				**			-3-6	·

Page 1

											DQA:	Date:			
NCR:	Yes	/ No				WORK ORDER NON-	WORK ORDER NON-CONFORMANCE / UPDATE								
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Work Ord	ler:					DISPOSITION	AGAINST DEPARTMENT/PROCESS								
Part NCR	No.					Rework Scrap Use-as-is Work Order Update	Machining Small Fa Thermoforming Finishin			ab ng	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other		
Root					Descri	ption of work order update		Initial	Action		Sign &				
Cause		Date	Step	Qty		or Non-conformance	Ch	nief Eng	Description		Date	Verification	QC Inspector		
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Land	ing G	Gear				General		_			_		_		
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		Centre No	ot Concer	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure		
		Cracks	•			Broken/Damaged		Inspection Incomplete			Part Incorred	ct -	Weld		
	П	Crushed/	Crimped.			Burrs		Instructions Incomplete/Unclear			Part Lost/Mi	ssing	Wrong Stock Pulled		
Cuffs						Contamination		Mainte	nance		Part Moved	<u> </u>	_		

Mislabeled

Out of Calibration

Out of Sequence

Outside Dimensions

Misread

Offset

Positioned Wrong

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

Countersink

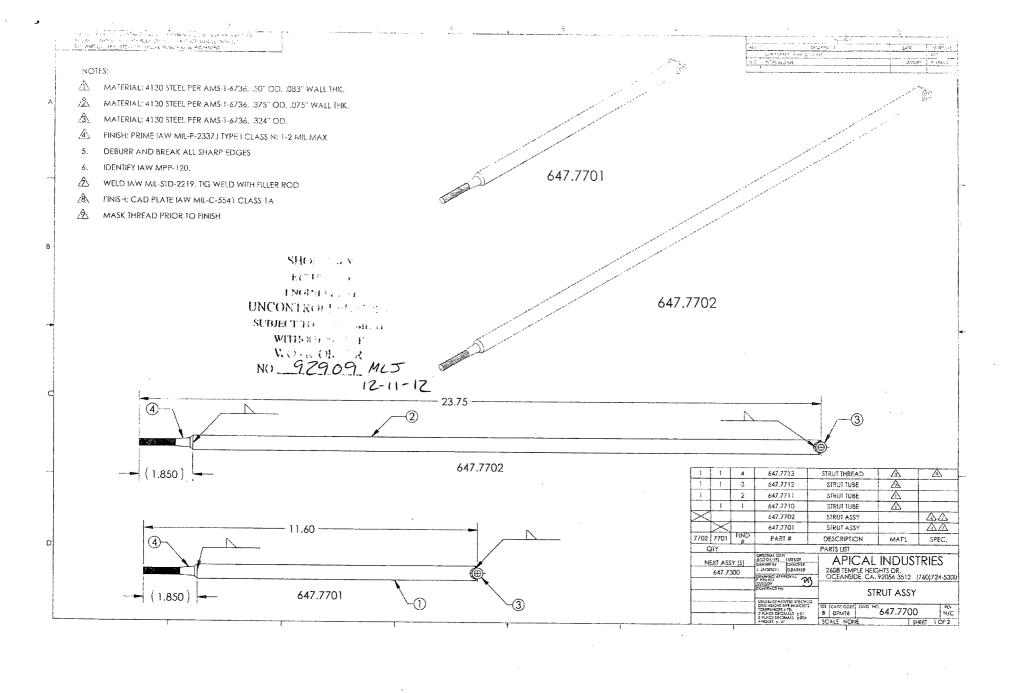
Cut Too Short

Drill Holes

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G



									,			DQA:	Da	te:	
NCR:	Yes	/ No				WORK ORDER NON-	100	NFORI	MANCE / UP	DATE		•			
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Work Ord	er:					DISPOSITION				AGAINST D	AINST DEPARTMENT/PROCESS				
						Rework	1	l	Skid-tube	Crosstube		Water Jet			Engineering
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	Crushed/Crimped					Burrs		Instructions Incomplete/Unclear				Part Lost/Missing			Wrong Stock Pulled

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Part Moved

Positioned Wrong

Power Loss/Surge

Other

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

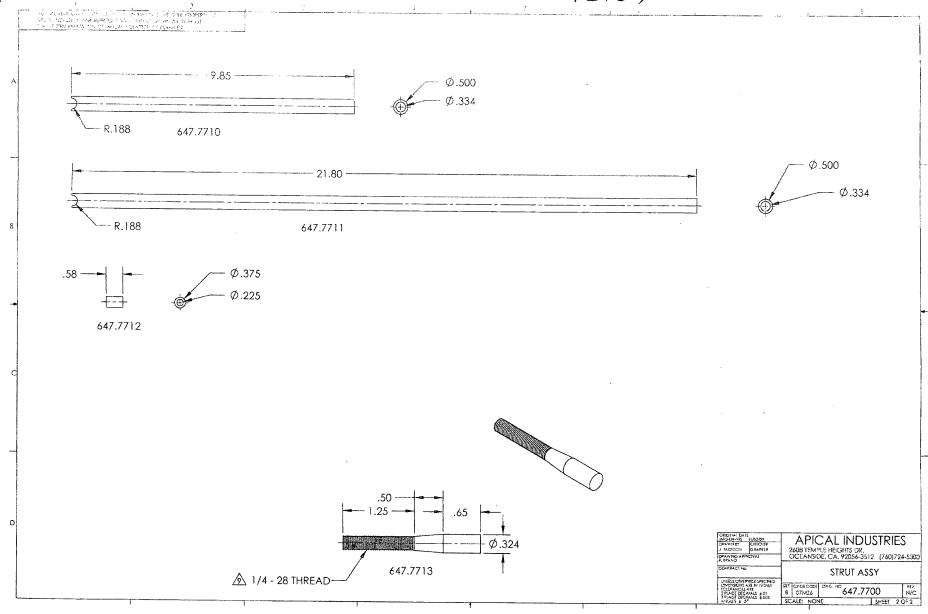
Cuffs

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G



NCR:	NCR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE													
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Work Orde	or.					DISPOSITION		AGAINST DEPARTMENT/PROCESS						
Work Orac	-''-					Rework	7	Skid-tube Crosstube			Water Jet	Engineering		
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	Cracks					Broken/Damaged	⊢	tion Incomplete		Part Incorre		Weld		
	_		rimped.			Burrs	 	tions Incomplete/Unclear	<u> </u>	Part Lost/Mi	issing	Wrong Stock Pulled		
ļ	Cuff				_	Contamination	\vdash	enance	⊢	Part Moved				
	—	t Treat				Countersink	Mislab			Positioned V		_		
	Insp	ection	Strip in	Tube		Cut Too Short	Misrea	d		Power Loss/	Surge	Other		
	Ripp	oles in	Bend			Drill Holes	Offset							

Out of Calibration

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

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Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G